

Work Order ID 66408

Monday, February 14, 2011 4:23:42 PM



Page 1

Item ID: D206-642-411BL

Accept



Setup Start



Revision ID:

Blue

Stop



Item Name: Skidtube LH, Blue

Start Date: 2/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-411 CHG006

8 u103/21

Agdor CL 11-3-7 Pro →

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/3/7 SP RD

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8 u103/21

(40)

Dart Aerospace Ltd

W/O: 66408		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm change						
11/03/21	110	ADD Qty Per Kit under Qty Per Kit total column and ADD Partin numbers.	11/03/21	11.03.21			S 11/03/21	

Part No: D206-642-411 BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist

Monday, February 14, 2011 4:23:42 PM

Work Order

Parent Item

Parent Item

Comments:

Component
Item Name

AN3-41A

Bolt

AN4-6A

Bolt

AN4C5A

BOLT

Work Order ID 66408

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Page 2

Item ID: D206-642-411BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH, Blue

Start Date: 2/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-411

Location:

PPP Rev:

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/21

11/3/21

11-03-21

Dart Aer

Dart Aerospace Ltd

W/O:

DATE

W/O:

DATE

STEP

PROCEDURE CHANGE

By

Date

Qty

Approval
Chief Eng /
Prod Mgr

Approval
QC Inspector

WORK ORDER CHANGES

Part No:

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

DATE

NCR:

DATE

STEP

Description of NC
Section A

Corrective Action Section B

Initial
Chief Eng

Action Description
Chief Eng

Sign &
Date

Verification
Section C

Approval
Chief Eng

Approval
QC Inspector

WORK ORDER NON-CONFORMANCE (NCR)

NOTE: Date

NOTE: Date & initial all entries

H:\FORMS\Qu

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, February 14, 2011 4:23:34 PM

Page 2

Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00



Purchased No

Each 59.0000



8
11/3/11

Location

Loc Qty

Loc Code

ST

17

115374

17

ST337

25

116419

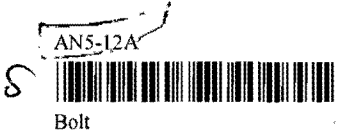
25

ST338

17

115422

17



Purchased No

Each 54.0000



4
11/3/11

Location

Loc Qty

Loc Code

ST338

54

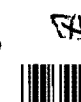
112314

54



Purchased No

Each 100.0000



4
11/3/11

Location

Loc Qty

Loc Code

ST358

100

116003

100



Purchased No

Each 29.0000



1
11/6/11 11/3/11

Location

Loc Qty

Loc Code

ST346

29

100993

29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

Each 8.0000



Washer

85 8

M116583 11/3/11

Location Loc Qty Loc Code

ST 6

107715 6

ST335 2

105792 2

AN960JD416 NAS1149D0463J Purchased No

Each 30.0000



Washer

24 24

M117065 10/3/11

Location Loc Qty Loc Code

ST300 24

113288 24

ST356 6

115622 6

AN960JD516 NAS1149D0563J Purchased No

Each 34.0000



Washer

85 8

M116540 11/3/11

Location Loc Qty Loc Code

ST 34

103694 18

107534 12

109287 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

D206-642-441

Manufactured No

Each

6.0000



Replacement Skidtube

66410 1/13/11 SP

Location

Loc Qty

Loc Code

FG080

6

24739

1

30265

1

30266

1

30940

1

31066

1

35469

1

D206-648-013

Manufactured No

Each

2.0000



GHW Modification

B66451 1/13/11 SP

Location

Loc Qty

Loc Code

FG120

2

66042

2

ATT: BLUE LUG

D2652

Manufactured No

Each

260.0000



Bushing

16 1/13/11 SP

Location

Loc Qty

Loc Code

FG

44

31985

44

ST020

216

61645

1

64267

6

64770

103

65049

106

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2712

Manufactured No

Each

388.0000



Set Screw



10
11/3/21

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST021	250	
65115	250	
ST022	88	
61331	88	

D2932-1

Manufactured No

Each

2.0000



Saddle LH Out, 206



1
66397

Location

Loc Qty

Loc Code

ST428	1	
63584	1	
ST428A	1	
64464	1	

ATT: BLUE

D2933-1

Manufactured No

Each

3.0000



Saddle LH In, 206



1
66398 11/3/21

Location

Loc Qty

Loc Code

ST428	3	
63583	2	
64465	1	

ATT: BLUE

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Monday, February 14, 2011 4:23:35 PM

Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

8 D2934
Saddle Spacer

Manufactured No

Each

36.0000

72 2
11/3/7

SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST028

30

66043

30

Each

23.0000

72 2
11/3/7

2
11/3/7 SP

8 D2935
Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST028

23

63558

23

Each

0.0000

71 1
B66399

2
11/3/7 SP

S D2938-1
Saddle LH Out, 206
ATT: BLUE

Manufactured No

S D2939-1
Saddle LH In, 206

Manufactured No

Each

3.0000

71 1
66400

1
66400 2/4/3/10

Location

Loc Qty

Loc Code

ST428A

3

63582

1

64181

2

ATT: BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 14, 2011 4:23:37 PM

Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

ID3407-043

Manufactured No

Each

6.0000



Tow Ring



11/3/11

Location

Loc Qty

Loc Code

ST420

1

62627

1

ST464

5

50387

1

64071

4

ATT: BLUE

D3413-1

Manufactured No

Each

25.0000



Ring



11/3/11

Location

Loc Qty

Loc Code

ST420

9

62961

9

ST473

16

51586

1

53446

5

65294

10

ATT: BLUE

D3456-1

Manufactured No

Each

88.0000



Washer



11/3/11

Location

Loc Qty

Loc Code

ST058

88

63239

3

64282

85

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 14, 2011 4:23:37 PM

Work Order ID: 66408

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

Each

45.0000

72

2

11/3/75



Washer

Location

Loc Qty

Loc Code

FG	10	
32409	10	
ST059	35	
45913	1	
<u>66030</u>	34	

Purchased No

Each

2,758.000

76

2

8

11/3/75

MS21042L3



Nut

Location

Loc Qty

Loc Code

ST300	2758	
114784	9	
<u>115835</u>	249	
116391	900	
116540	800	
116549	800	

Purchased No

Each

5,430.000

712

12

11/3/75

12

MS21042L4



Nut

Location

Loc Qty

Loc Code

ST300	5430	
1123143	2	
115589	10	
115621	20	
<u>116188</u>	3398	
116823	2000	

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, February 14, 2011 4:23:37 PM

Parent Item: D206-642-411BL

Parent Item Name: Skidtube LH, Blue

Start Date: 2/15/2011

Required Date: 3/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 -

Purchased

No

Each

1,022.000

Nut

Location

Loc Qty

Loc Code

ST301

1022

114523

5

114784

2

115936

119

116188

596

116549

300

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

D206-642

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4.6 206L/L-1/L-3/L-4 HIGH GEAR SKIDTUBES

Item	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	Part Number	Description
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-7	SKIDTUBE ASSEMBLY
2A			22			D2651-1	* PLUG ⁽¹⁾
2B			22			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-13A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)
22B			1	1		D3536-15	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)
24B			1	1		D3536-37	GASKET
26A			60	60		MS27039C1-08	SCREW
26B			60	60		AN960JD10L	WASHER
26C			60			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	LUG ASSEMBLY (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-7 ASSEMBLY ABOVE

⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09